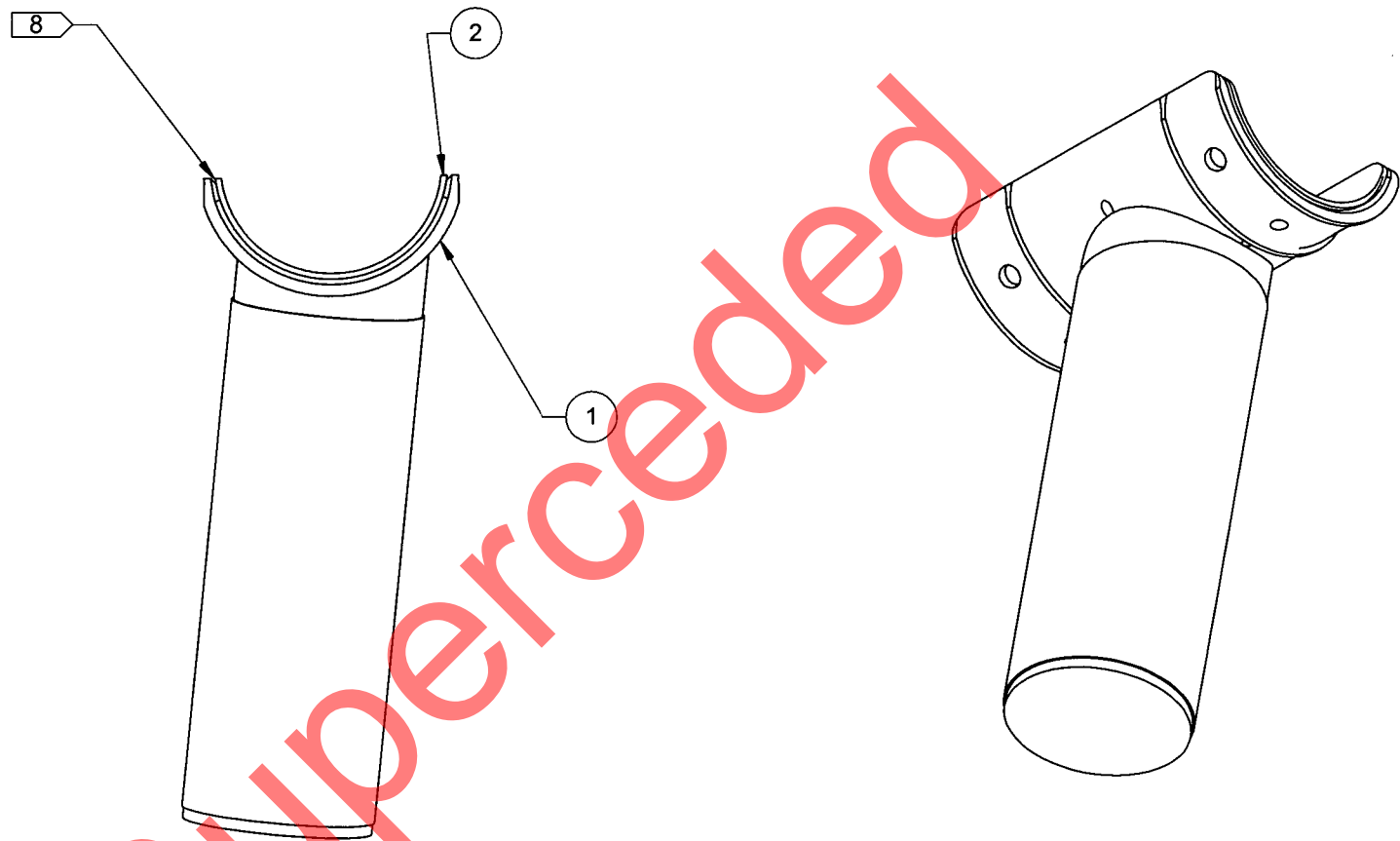


ITEM	QTY -041	P/N	DESCRIPTION
	X	D5149-041	FWD STEP ASSEMBLY
1	1	D5149-041W	FWD STEP BASE WELDMENT
2	1	D5151-1	CLAMP CUSHION



D5149-041 FWD STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.69 lbs
- 8) BOND D5151-1 CUSHION TO D5149-041W BASE WELDMENT USING 3M 1300L ADHESIVE

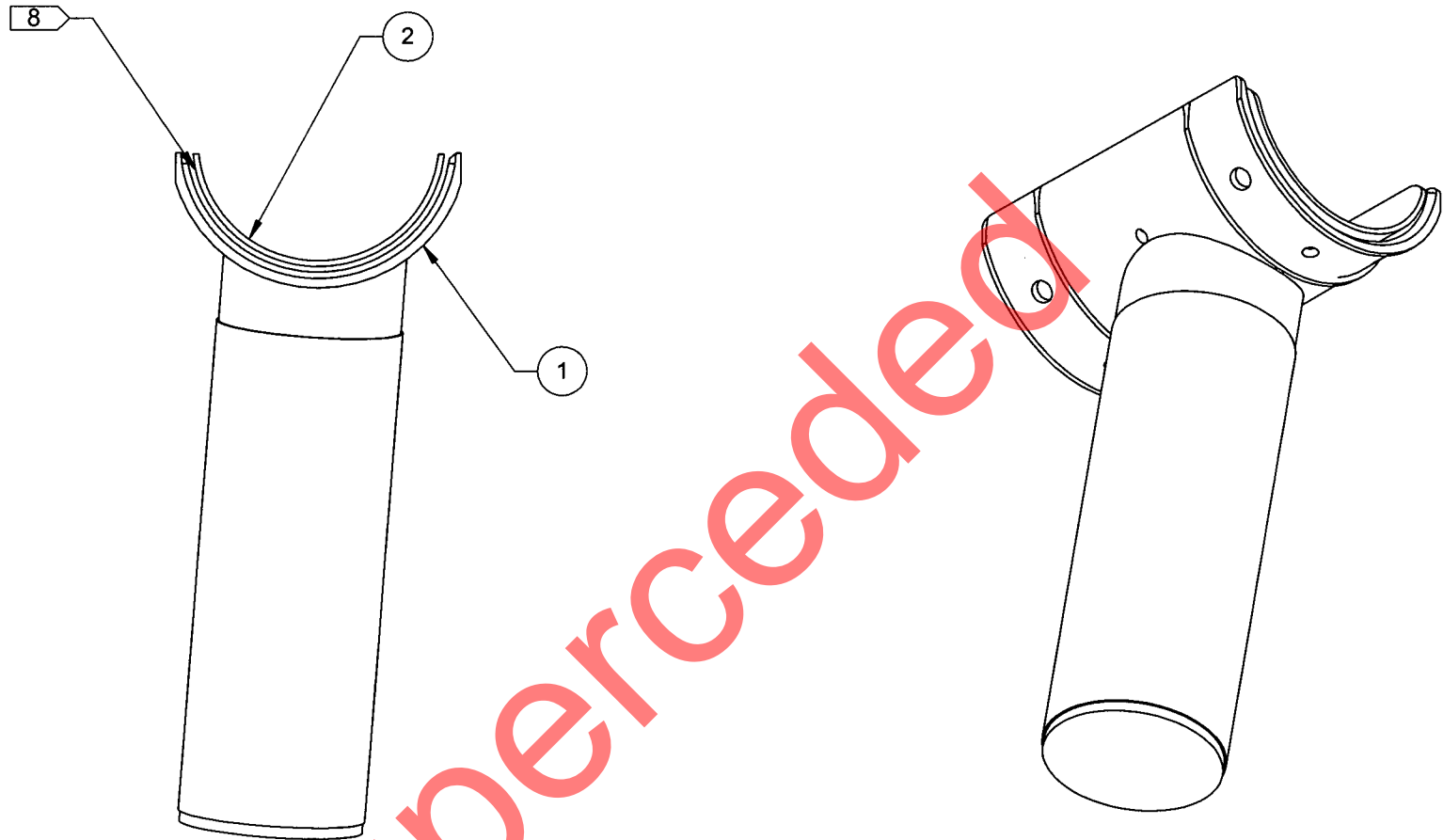
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2015 FEB 09

BCN 15-516 9P

APPROVED	B	COMPLETE RE-DESIGN, SEE PREVIOUS REV FOR DETAILS	DB	15.01.14
	A	NEW ISSUE	DB	14.10.25
	REV.	DESCRIPTION	BY	DATE
	DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	DB		
	CHECKED	AP	DRAWING NO.	REV. A
	MFG. APPR.	DD	D5149	SHEET 1 OF 11
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	STEP ASSEMBLY	NTS
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ITEM	QTY -043	P/N	DESCRIPTION
	X	D5149-043	AFT STEP ASSEMBLY
1	1	D5149-043W	AFT STEP BASE WELDMENT
2	1	D5151-3	CLAMP CUSHION



D5149-043 AFT STEP ASSEMBLY

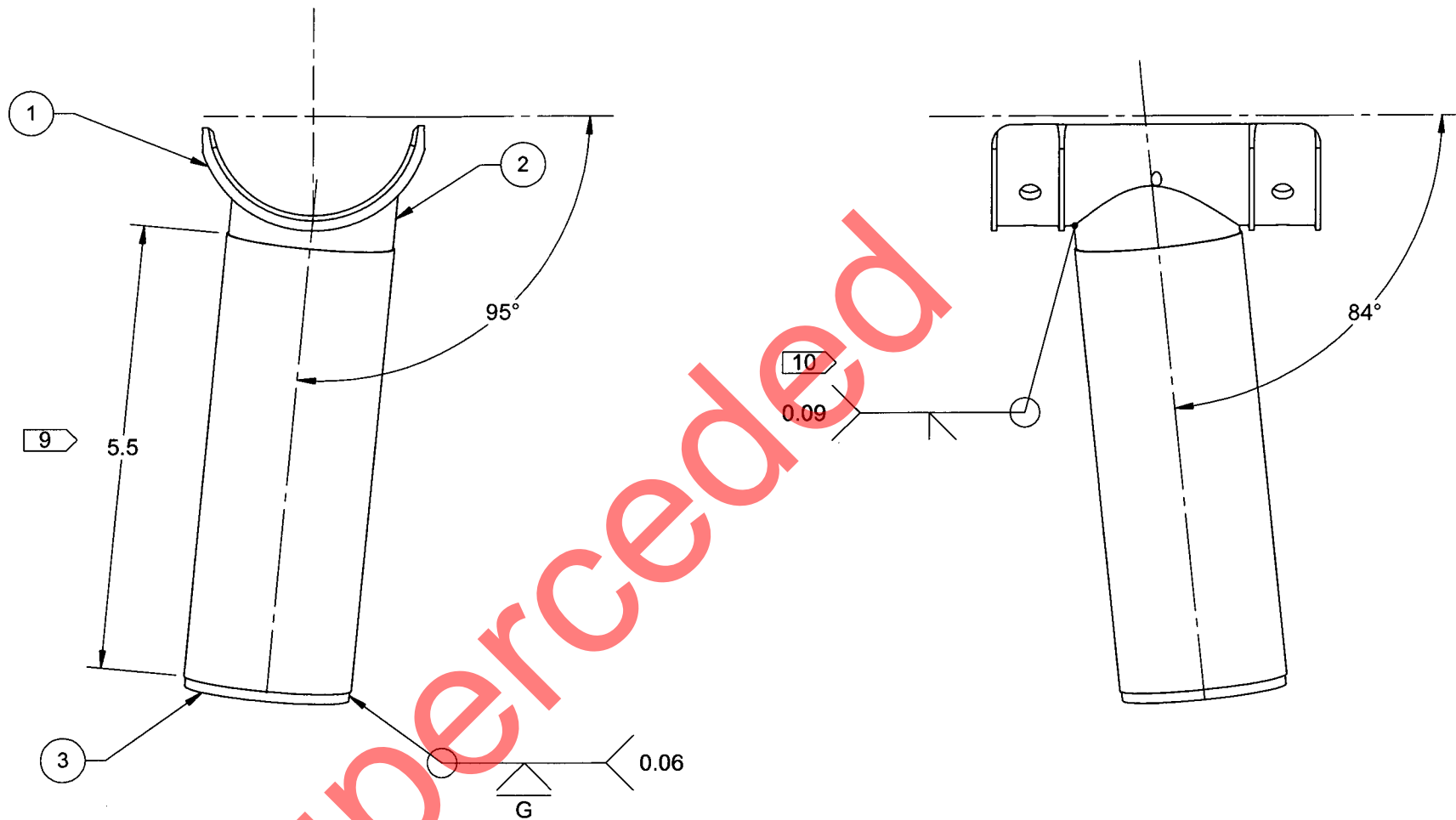
RELEASED
2015 FEB 09 *qp*

APPROVED

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.87 lbs
 - 8) BOND D5151-3 CUSHION TO D5149-043W BASE WELDMENT USING 3M 1300L ADHESIVE

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DRAWN	DB		
CHECKED	AP	DRAWING NO. D5149	REV. <i>A</i> B
MFG. APPR.	DD	SHEET 2 OF 11	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS <i>#</i>	STEP ASSEMBLY	NTS
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ITEM	QTY-041W	P/N	DESCRIPTION
	X	D5149-041W	FWD STEP BASE WELDMENT
1	1	D5149-1	FWD STEP BASE
2	1	D5149-3	FWD STEP
3	1	D5149-5	STEP CAP



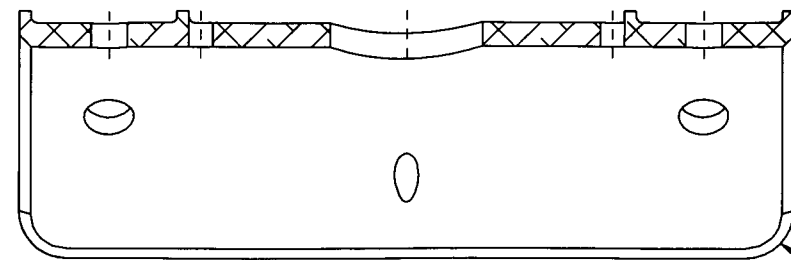
D5149-041W FWD STEP BASE WELDMENT

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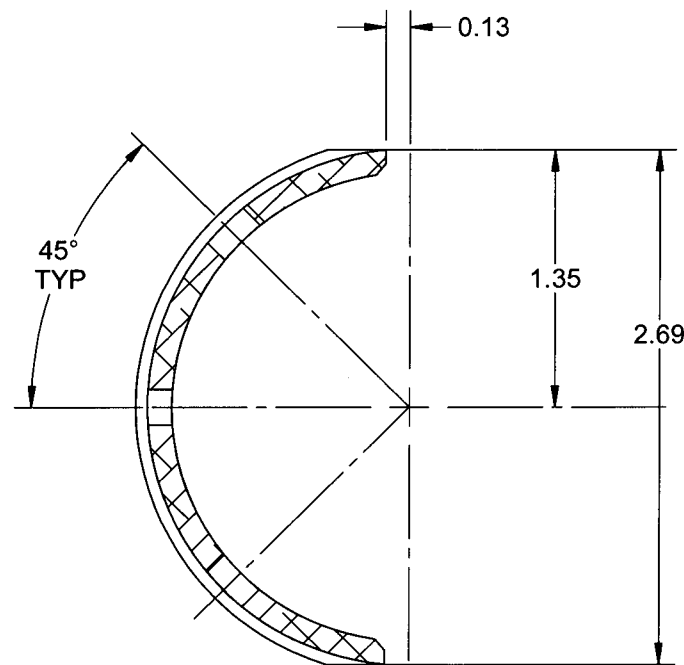
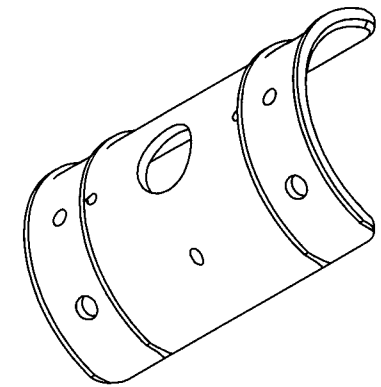
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.67 lbs
 - 8) WELDING PER DART QSI 004
 - 9) APPLY BLACK ANTI-SKID PAINT TO STEP TUBE, ALL AROUND PER DART QSI 005 4.4
 - 10) ALIGN D5149-3 FWD STEP WITH EDGE OF ALIGNMENT HOLES IN D5149-1 FWD STEP BASE PRIOR TO WELDING

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	DRAWN	DB		
	CHECKED	AP	DRAWING NO.	REV. A
	MFG. APPR.	DD	D5149	SHEET 3 OF 11
	APPROVED	HS	TITLE	SCALE
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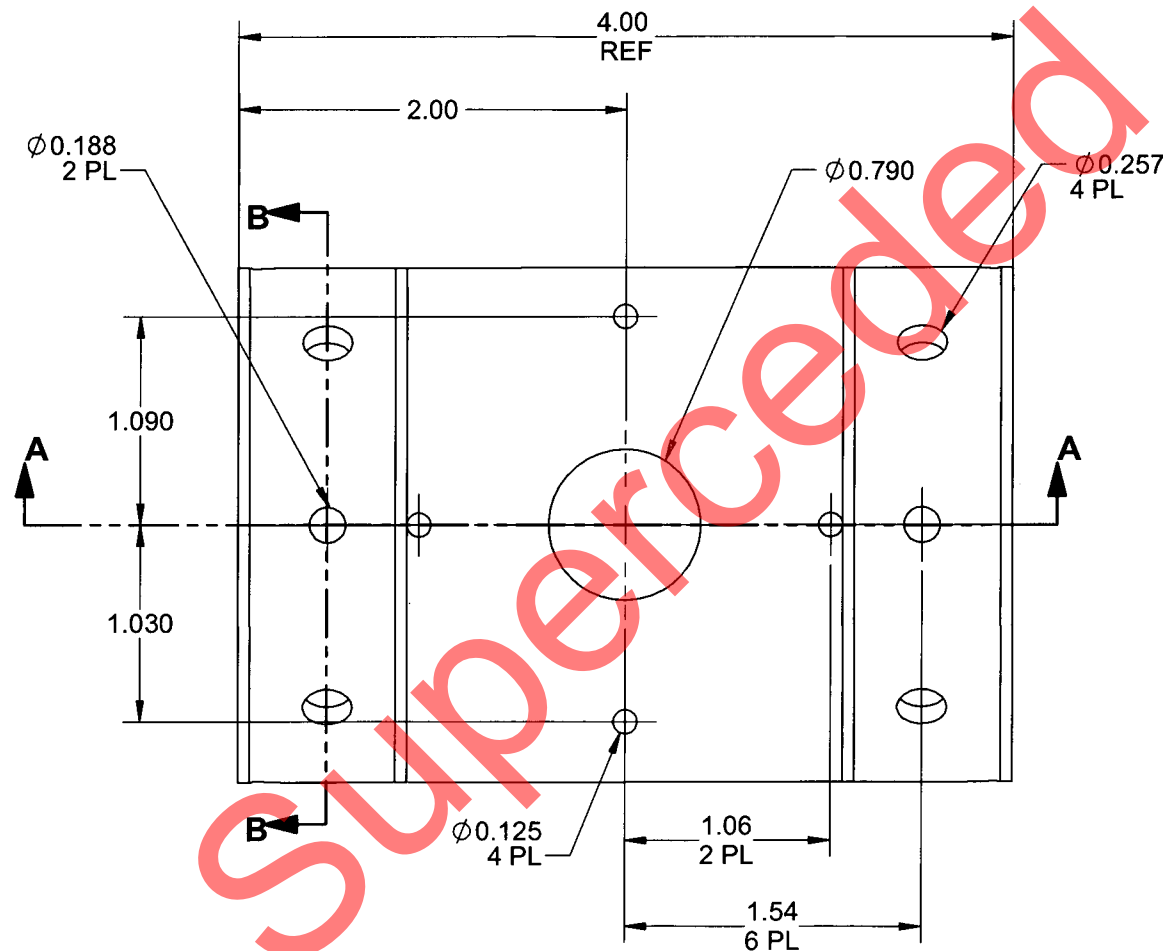


SECTION A-A

0.06 X 45° CMF
ALL AROUND INSIDE EDGE



SECTION B-B



D5149-1 FWD STEP BASE
(MAKE FROM D5149-1TRN)

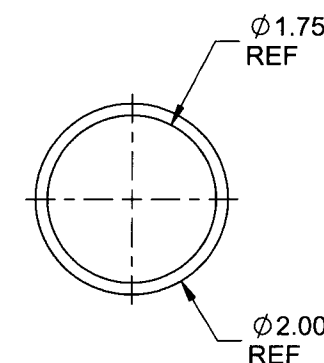
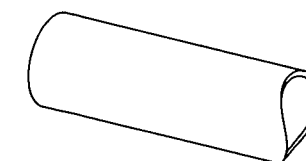
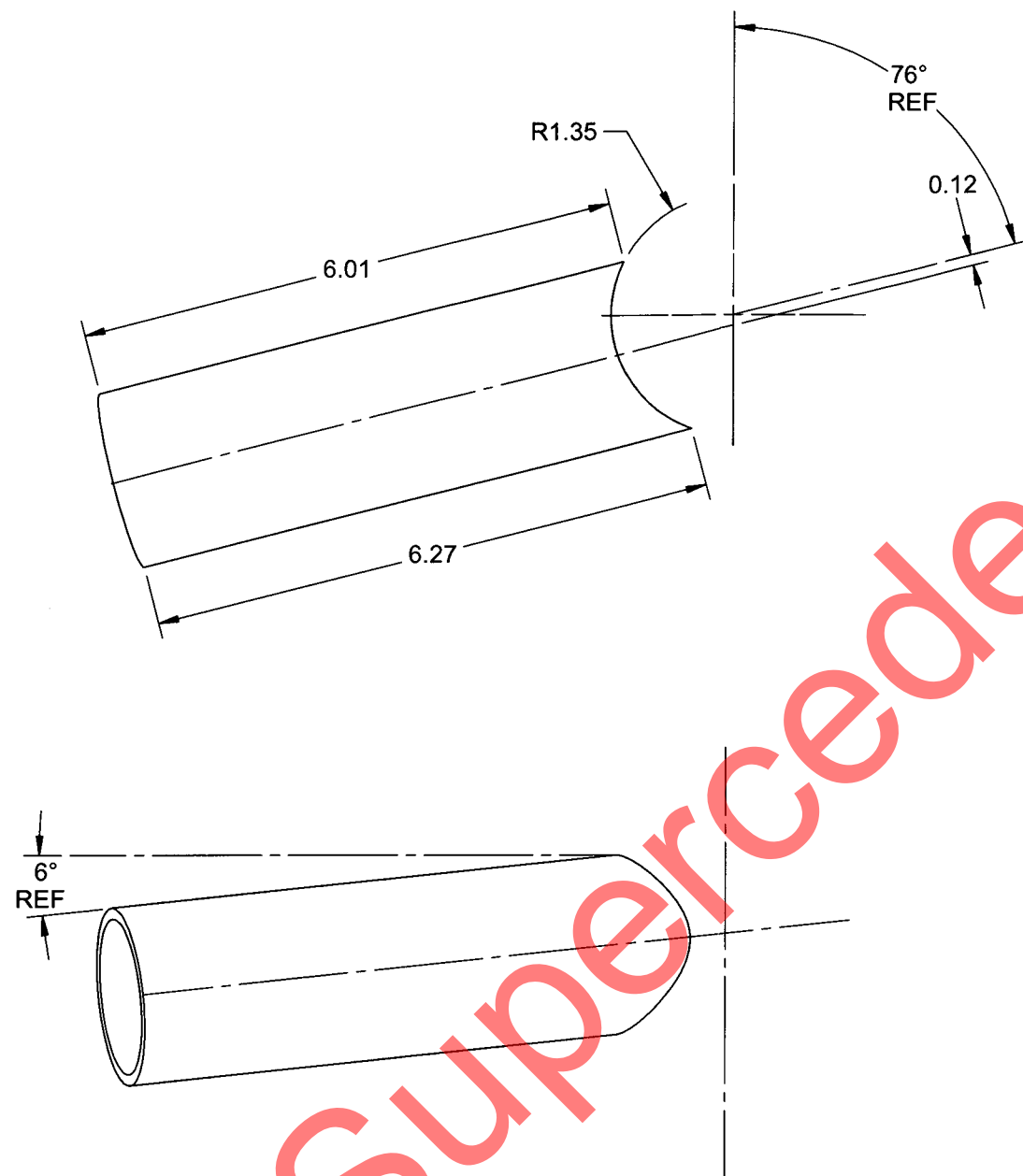
- NOTES:**
- 1) MATERIAL: MAKE FROM D5149-1TRN
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.20 lbs

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D5149-3 FWD STEP

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NOTES:

1) MATERIAL: 6061-T6/T62/T6510/T6511 SEAMLESS TUBING PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
OR AMS 4080 OR AMS 4082 OR AMS 4083 OR ASTM B210 OR ASTM B241
REF DART SPEC M6061T6T2.000W0.125

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

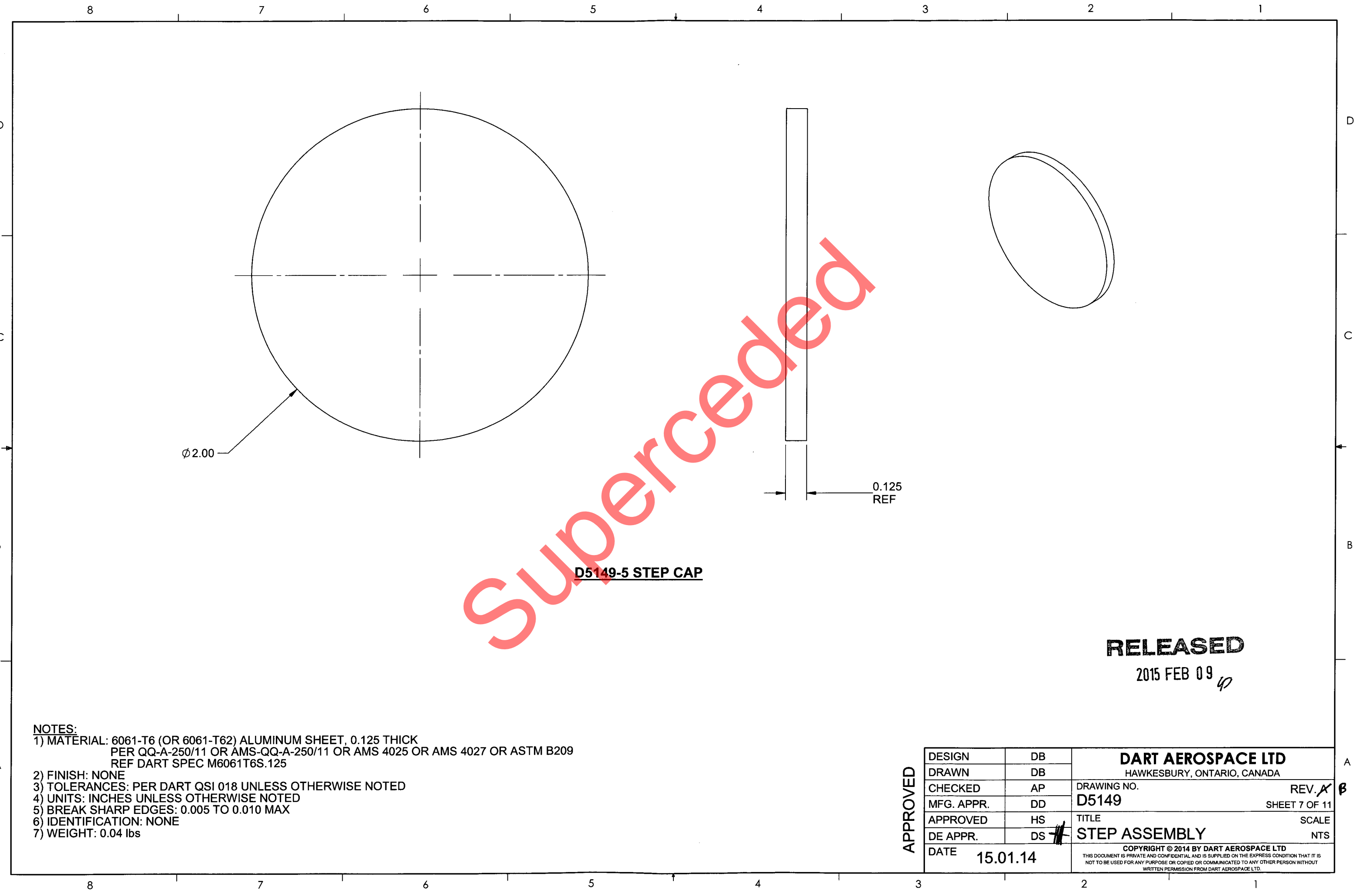
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 0.42 lbs

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DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO. D5149	REV. A
MFG. APPR.	DD		SHEET 6 OF 11
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STEP ASSEMBLY	NTS
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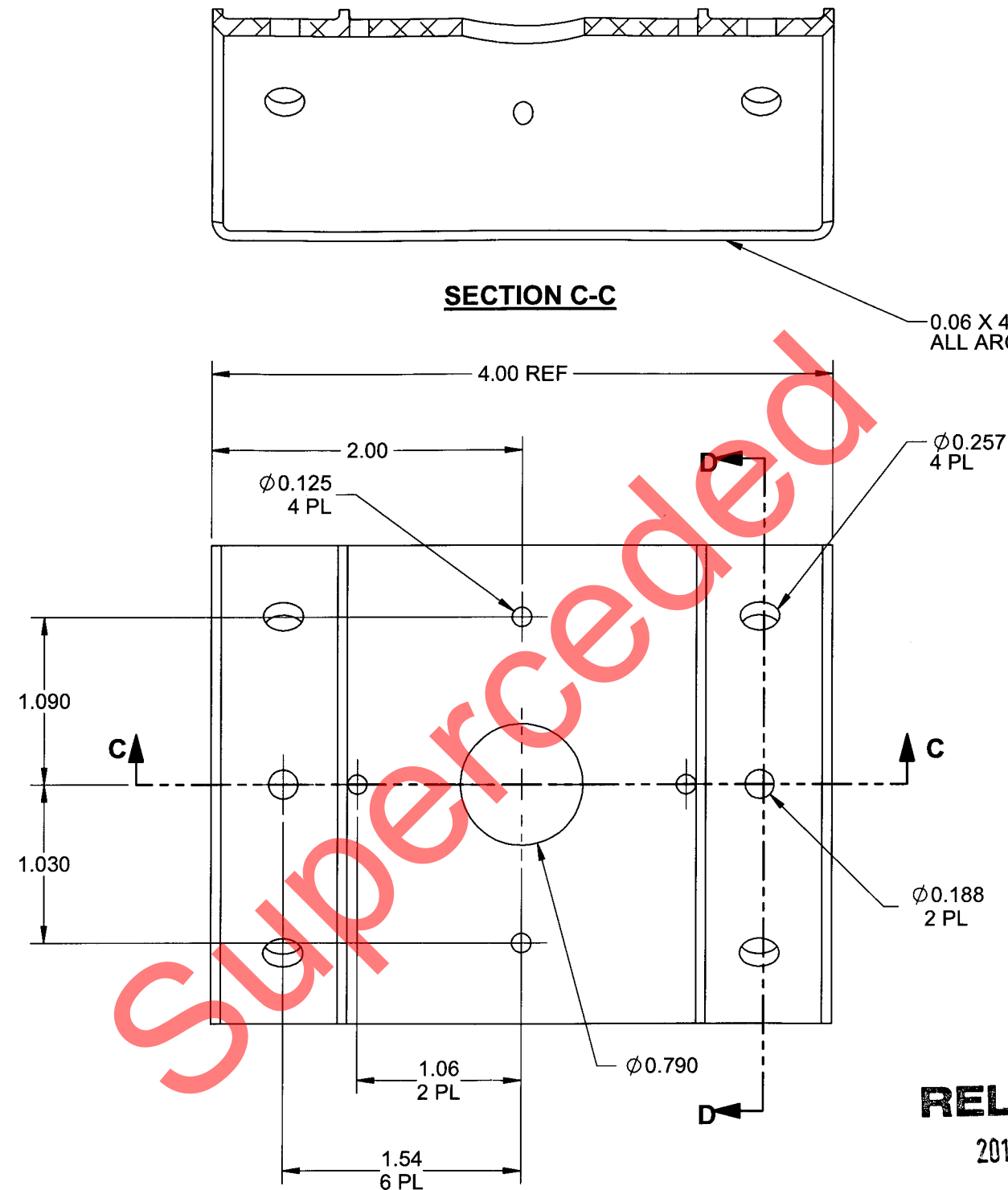
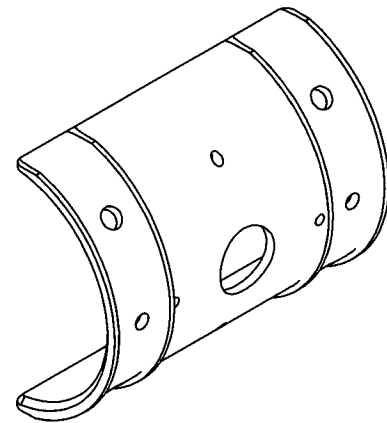
D5149-5 STEP CAP

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2015 FEB 09

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.04 lbs

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DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
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0.06 X 45° CMF
ALL AROUND INSIDE EDGE

Ø0.257
4 PL

Ø0.188
2 PL

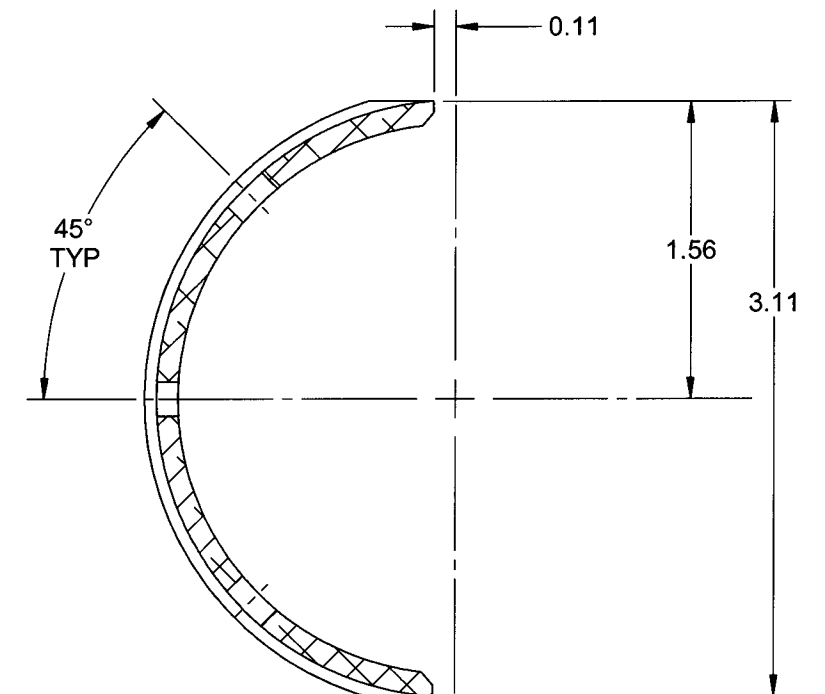
Ø0.790

1.06
2 PL

1.54
6 PL

1.090

1.030



D5149-7 AFT STEP BASE
(MAKE FROM D5149-7TRN)

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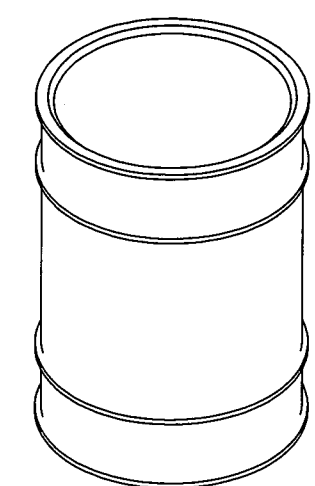
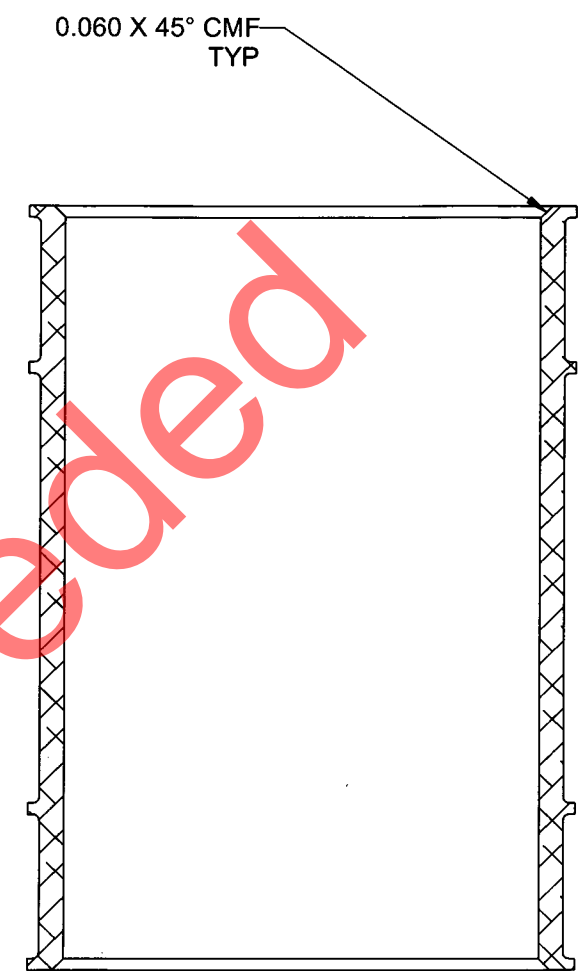
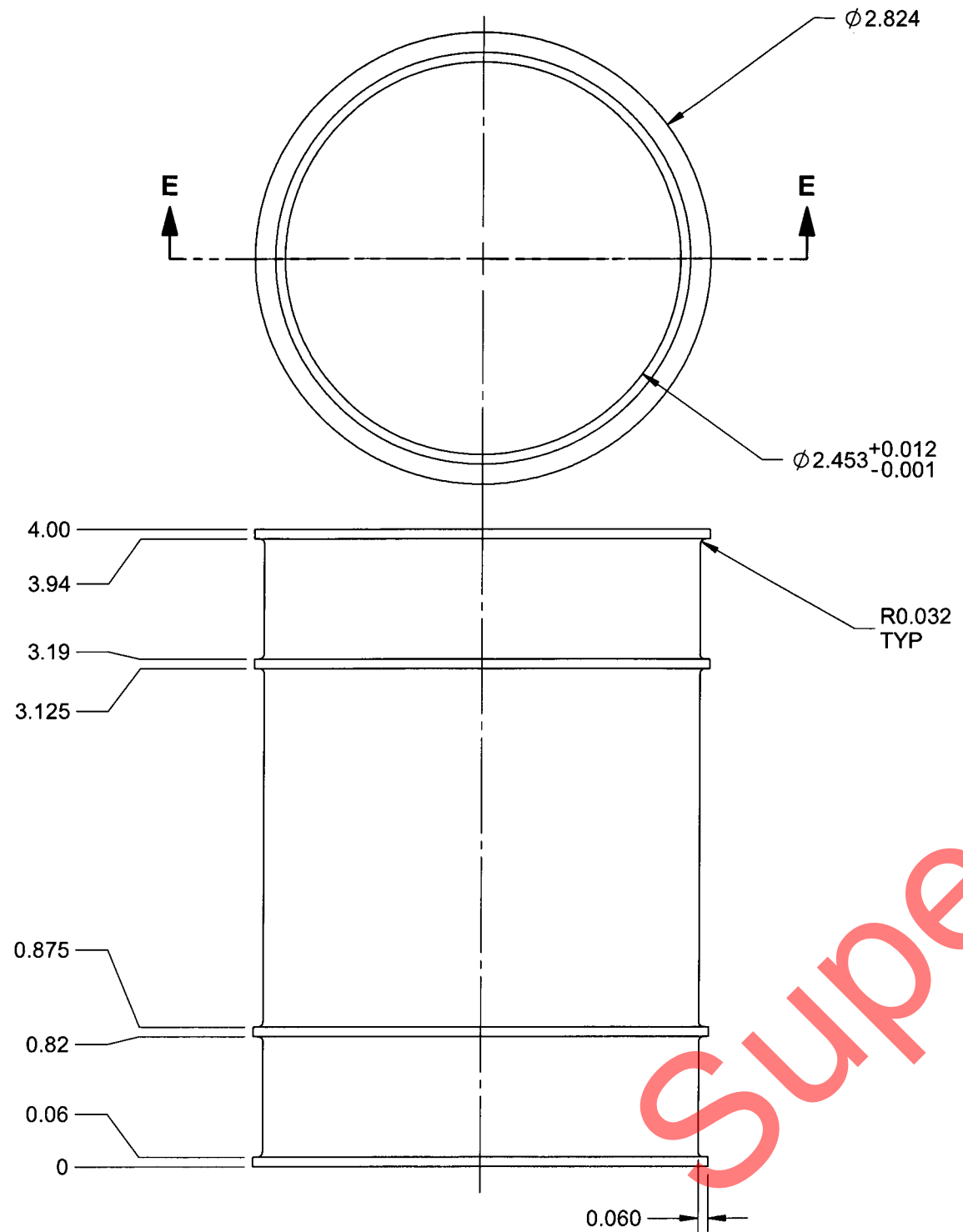
SECTION D-D

NOTES:

- 1) MATERIAL: MAKE FROM D5149-7TRN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.30 lbs

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DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO. D5149	REV. A
MFG. APPR.	DD	SHEET 8 OF 11	
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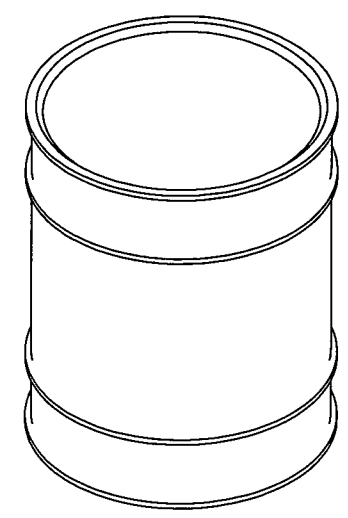
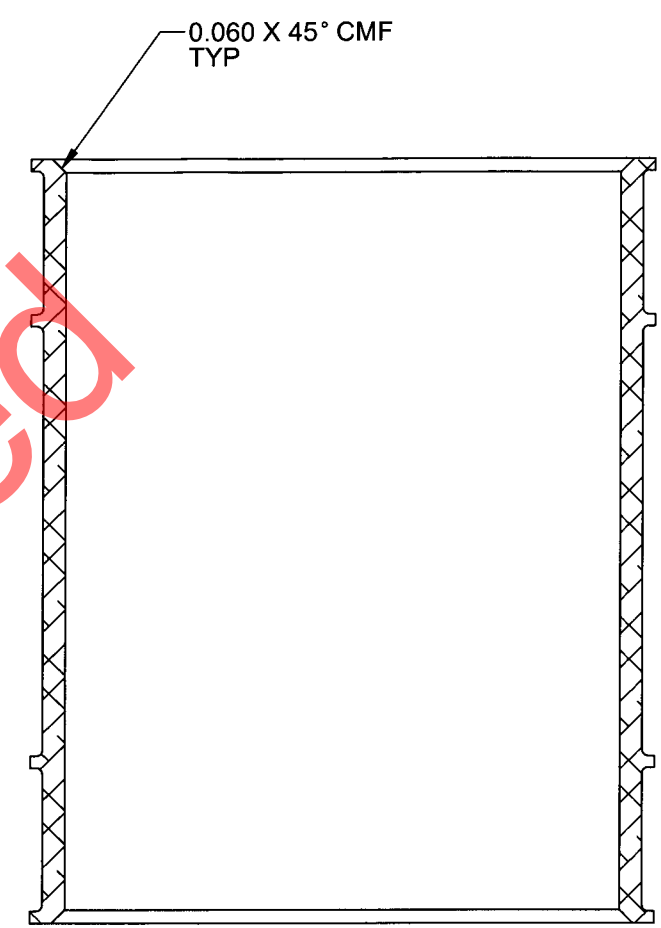
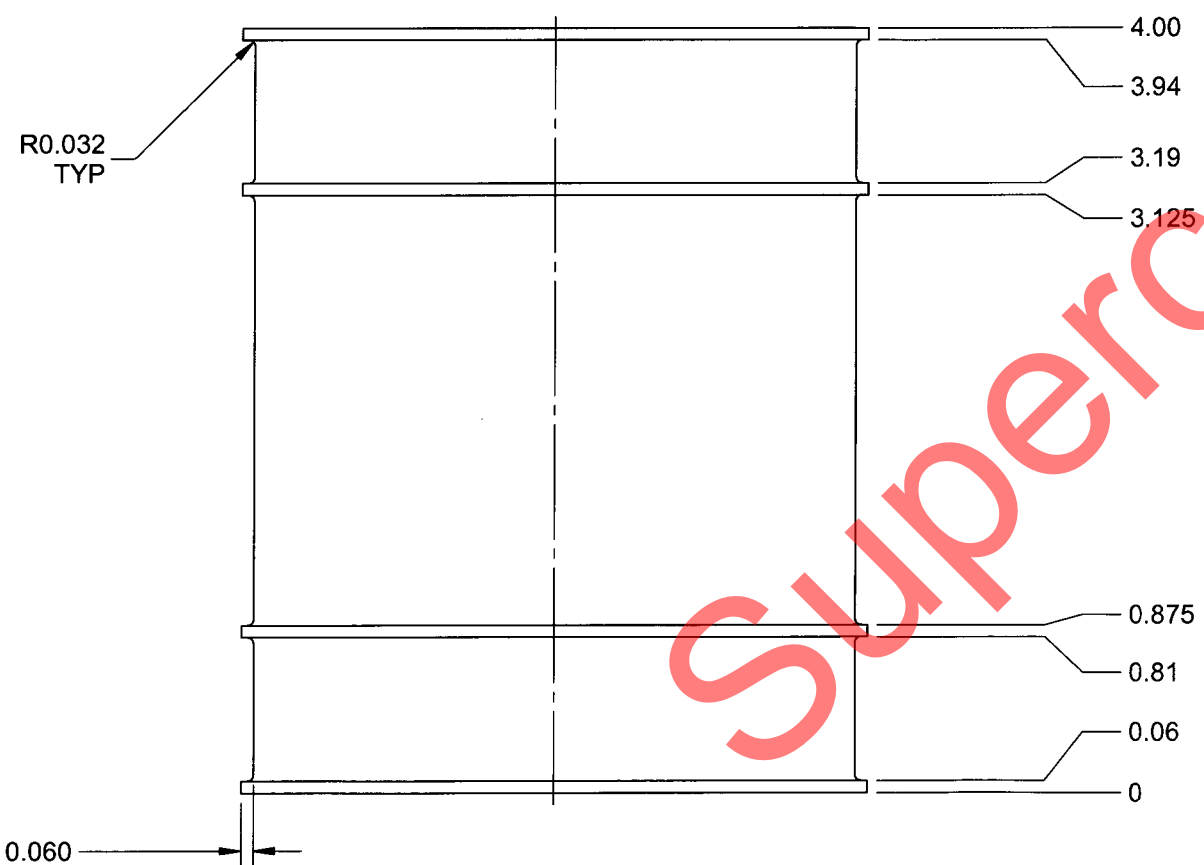
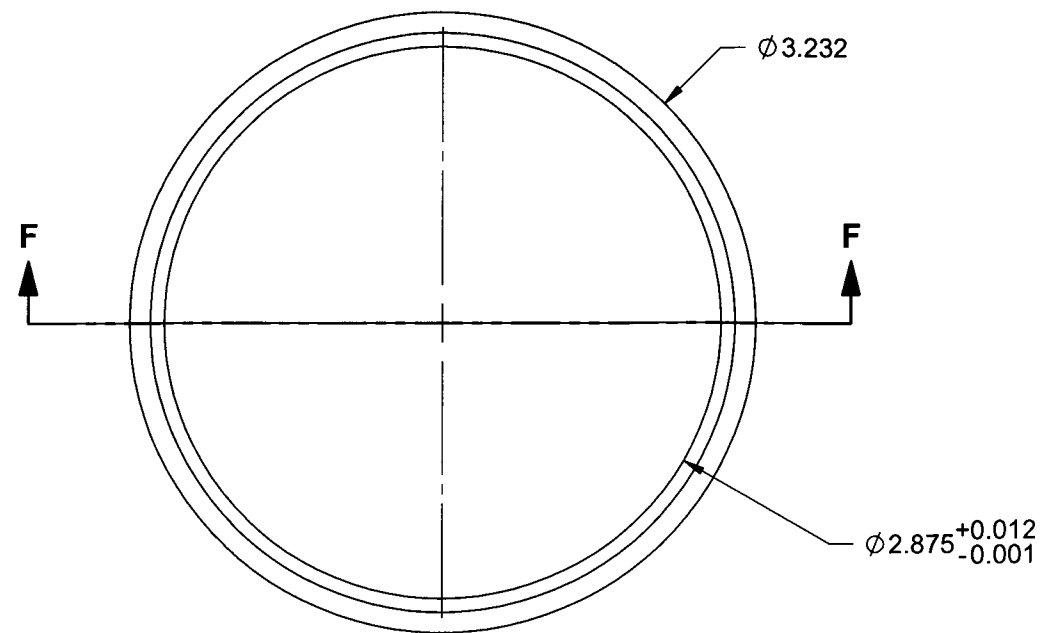
D5149-1TRN TURNING DETAIL

RELEASED
2015 FEB 09

- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF DART SPEC. M6061T6R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.41 lbs

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DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D5149	SHEET 9 OF 11
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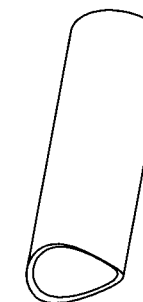
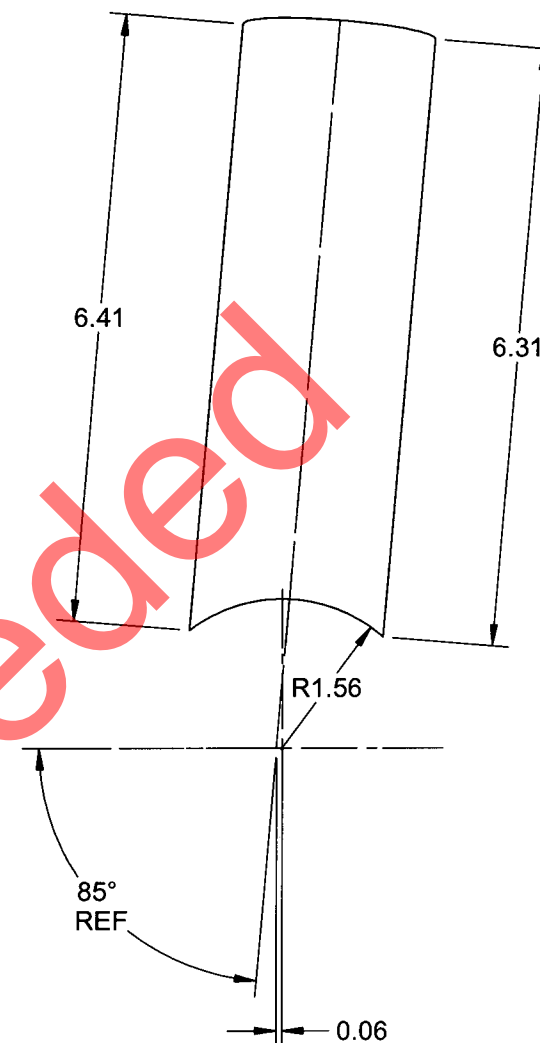
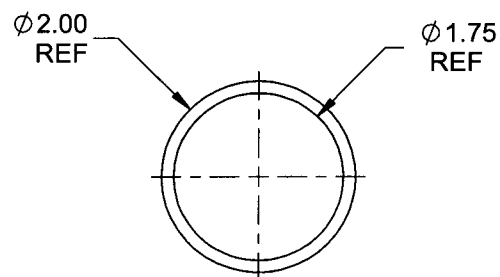
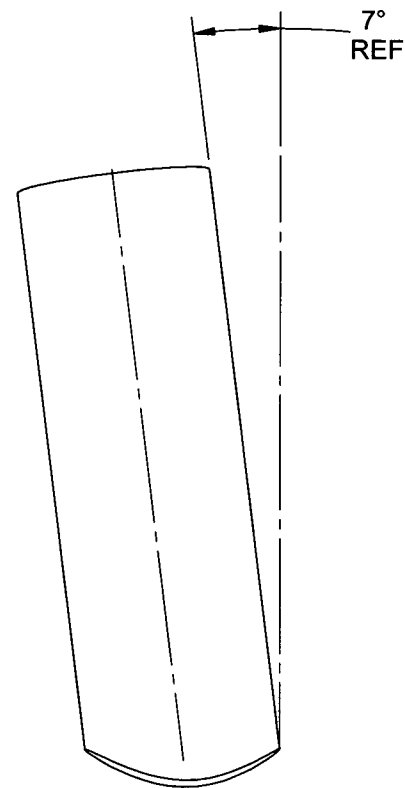
SECTION F-F

D5149-7 TRN TURNING DETAIL

- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF DART SPEC. M6061T6R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.41 lbs

RELEASED
2015 FEB 09

APPROVED	DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	DB		
	CHECKED	AP	DRAWING NO. D5149	REV. A
	MFG. APPR.	DD	SHEET 10 OF 11	
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D5149-9 AFT STEP

RELEASED

2015 FEB 09 *qp*

NOTES:

- 1) MATERIAL: 6061-T6/T62/T6510/T6511 SEAMLESS TUBING PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8 OR AMS 4080 OR AMS 4082 OR AMS 4083 OR ASTM B210 OR ASTM B241
REF DART SPEC M6061T6T2.000W0.125
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.44 lbs

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. <i>A</i>
MFG. APPR.	DD	D5149	SHEET 11 OF 11
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